

Work Order ID 57347

April 6, 2010 8:10:35 AM



Page 1

Item ID: D2580-1

Accept



Setup Start



Revision ID:

Item Name: 205 Skidtube bent detail

Stop



Start Date: 06/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 13/04/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

PS

Date:

10-4-06

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



HandFinish

Memo

0.00

Hand Finishing

1- Inspect mat'l D2500-1-190 for damage.

2- Chemical Conversion Coat as per QSI 005 4.1

2 - AWM 10-4-19

101

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

(2 ps) MG 10-04-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 13/04/2010 Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Drill pilot holes using drill jig DT 8149 (Do not use cutting fluid)

2-Open holes to 0.500" as per Dwg D2580 without cutting fluid

3-Deburr and blow out all chips from inside of tube

4-Bond web in place per QSI 015.

□□

A/R Sikaflex-291 batch 1112429 □□□

Sikaflex expire date: 08/2010

Start time: 8:00 bond for 12hrs

10/04/10

2

BE 10/04/20

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

Memo

0.00

DP

10-4-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Work Order ID 57347

April 6, 2010 8:10:35 AM



Page 3

Item ID: D2580-1

Accept



Setup Start



Revision ID:

Stop



Item Name: 205 Skidtube bent detail

Start Date: 06/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 13/04/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



Packaging

Identify as per dwg & Stock Location: *46*

0.00

Memo

0.00

Packaging

*DP**10-4-21*

150



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

*10/04/21**MF**10-4-21*

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NOTE: Date & initial all entries

Picklist Print

April 6, 2010 8:10:39 AM

Page 1

Work Order ID: 57347



Parent Item: D2580-1

Parent Item Name: 205 Skidtube bent detail

Start Date: 06/04/2010

Required Date: 13/04/2010

Comments: IPP B01.11.08 Revised Step 9, 10, 12, and 13 SM

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2500-1-190 Ext'n - 'I' Beam Tube 4"		Manufactured	No				Each	62.0000	2.0000			

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

LG

52319

62

62

110

Each

2.0000

2.0000

(2) BE 12/04/20

D2596



Web, 205 Skidtube

Manufactured No

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

LG46

57121

2

2

257540

(4) x2

BE 12/04/20

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NOTE: Date & initial all entries

DART**RELEASED**
07.06.28 #

DESIGN #	DRAWN BY RH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57347

BS10-4406

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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RELEASED
07-06-28

Diagram illustrating the grinding locations for the D2576-3 step. The diagram shows a cross-section of the step with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576

Diagram illustrating the installation of a cap on a circular base. The diagram shows a cross-section of the cap and base, with the following components and dimensions labeled:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Points to the two small circular holes in the base.
- #0.208**: Dimension indicating the diameter of the holes.
- AN3-5A BOLT (1)**: Points to the bolt passing through the cap and base.
- AN960JD10L WASHER (1)**: Points to the washer between the cap and base.
- (2 PLACES)**: Points to the two locations where the bolt/washer assembly is installed.
- D2855 CAP**: Points to the cap being installed.
- SEAL WITH SIKAFLEX-241/-291**: Points to the sealant applied around the cap.
- 0.40**: Dimension indicating the thickness of the cap.

Diagram illustrating the wheel assembly components and inspection points:

- D2579 SPACER
- D2596 WEB (REF)
- ALS7-1032-130 (REF) (TYP 50 PLACES)
- AFTER PERFORM:
 1. CHA
 2. INS
 3. WE
 4. C'B

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

[illegible]

WELD AS PER DETAIL B

BLACK ANTI-SKID TO 0.5
ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP
TO 0.5 ABOVE BOTTOM EDGE

0.5 1.5 1.5 D P P P P P P P


8

REFER TO DETAIL C

D3566-1 D3566-5 D3566-13 D3564-11 D3564-5 D3564-9 D3564-13

AN3C4A BOLT (1)
AN960C10L WASHER (1)
(50 PLACES)

DESIGN	DRAWN BY

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	CHECKED	APPROVED		DRAWING NO.	REV. D
				D2580	SHEET 2 OF 3
	DATE			TITLE	SCALE
	07.02.27			205 SKIDTUBE ASSEMBLY	1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

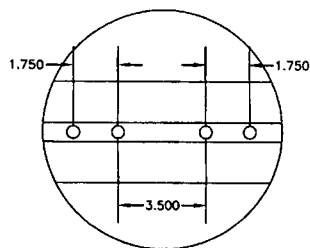
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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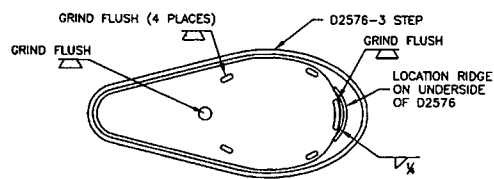
NOTE: Date & initial all entries

DETAIL E
SCALE 5:24

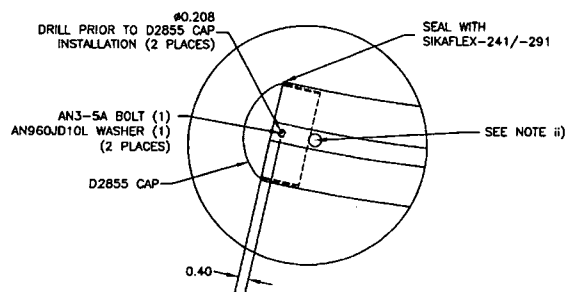


RELEASED
07.06.28

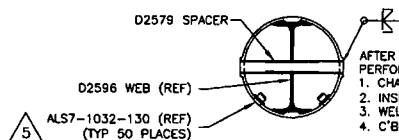
DETAIL F
SCALE 5:24



DETAIL G
SCALE 5:24



SECTION H-H
SCALE 5:24

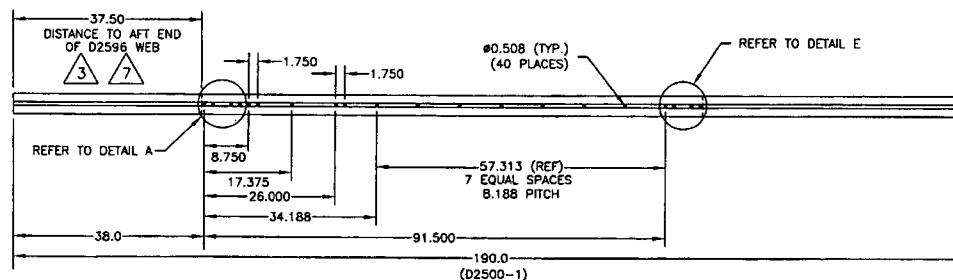


- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
 2. INSERT D2579 SPACER (20 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

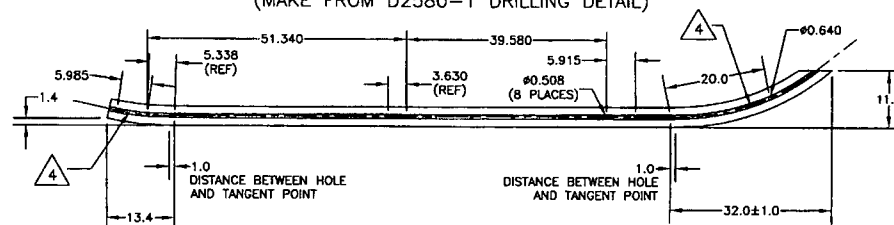
D2580-045 NOTES

- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

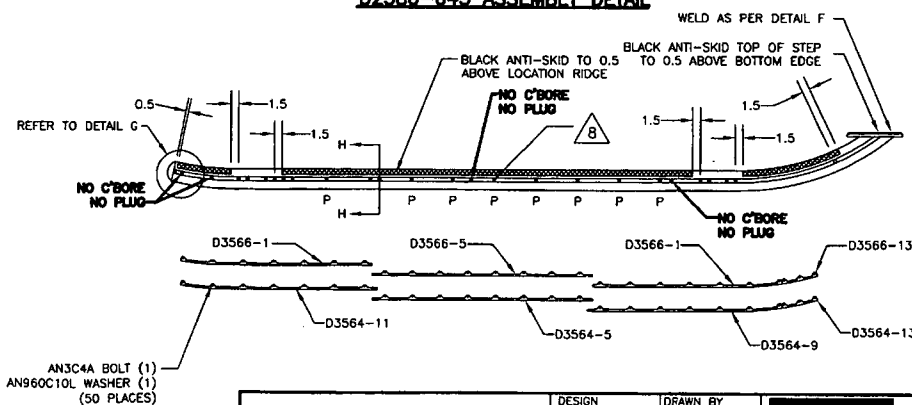
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



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DATE	TITLE	DRAWING NO.	REV. 0
07.02.27	205 SKIDTUBE ASSEMBLY	D2580	SHEET 3 OF 3
			SCALE 1:24

W/O:		WORK ORDER CHANGES					
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